

Work Order ID 51639

August 27, 2009 8:28:27 AM



Page 1

Item ID: D412-698-031

Accept



Setup Start



Revision ID: E

Stop



Item Name: Cabin Door Roller, LH

Start Date: 8/27/09 Start Qty: 2.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 09-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-031

CHG001

S 09/10/13

H for BG 09/09/25

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

9/9/25 2050

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

2) 809/10/13

(72)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51639

August 27, 2009 8:28:27 AM

Page 2

Item ID: D412-698-031

Accept

Revision ID: E

Item Name: Cabin Door Roller, LH

Start Date: 8/27/09 Start Qty: 2.00

Required Date: 8/31/09 Req'd Qty: 2.00



Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-031 Location: _____ LIPPP Rev: <u>12</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/14 (2)

09/10/14

MC 09-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:28:27 AM

Page 1

Work Order ID: 51639

Parent Item: D412-698-031RevE

Parent Item Name: Cabin Door Roller, LH

Start Date: 8/27/09

Required Date: 8/31/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-143RevE 1x Manufactured No

120

Each

9.0000

2.0000



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

46036

9

120

Each

48.0000

2.0000

D3137-043RevF 1x Manufactured No



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

29725

4

42192

44

120

Each

19.0000

2.0000

D3183-043RevC1 1x Manufactured No



Bracket Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

42193

4

46030

10

47647

5

① B45085

① 46036 sf ✓

9/9/25

42192 sf ✓

9/14/13 (2)

46030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:28:27 AM

Page 2

Work Order ID: 51639

Parent Item: D412-698-031RevE

Parent Item Name: Cabin Door Roller, LH

Comments:

Start Date: 8/27/09

Required Date: 8/31/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3202-3RevD 1P Cover		Manufactured	No			120	Each	9.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

42516

9

D3674-041RevA 3P BRACKET ASSEMBLY		Manufactured	No			120	Each	48.0000	6.0000			
--------------------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48

40122

3

42514

39

47645

6

D3675-1RevB 9X SLIDING DOOR BRACKET		Manufactured	No			120	Each	84.0000	18.0000			
--	--	--------------	----	--	--	-----	------	---------	---------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

40347

4

42515

80

August 27, 2009 8:28:27 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1				D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1		1		D3202-3	COVER
		3				D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

57639

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E

Date: 08.05.01